

# Work Order ID 58574

May 12: 2010 7:55:14 AM



Page 1

Item ID: D350-600-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, LH, AS350

Start Date: 5/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-600-241  
CHG 001

5/10/10

110

0.00



Small Fab

Small Fab

Memo

0.00

1-Drill holes in D3188-1 using drill jig Dt8970  
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188  
3-Deburr  
4-Install inserts in D3188-1 as per dwg D3188

ET

10-05-12

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

5/10/10

20

# Work Order ID 58574

May 12, 2010 7:55:14 AM



Item ID: D350-600-241

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Setup Start



Revision ID:

Stop



Item Name: Spacepod, LH, AS350

Start Date: 5/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

140



Small Fab

Small Fab

0.00

Memo

0.00

\*\*\* this step seperates hardware, previous steps is for baody & floor\*\*\*



**Work Order ID 58574**

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Item ID: D350-600-241

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00



Small Fab

Memo

0.00

IT 10-05-12

Small Fab

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600  
\*\*\*Hardware on previous steps is for door ass'y\*\*\*

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with  
milled glass fibres 10% to weight

A/R Hysol batch: 113022

xpiry date: 10-10-27

A/R Milled fibers batch: 100859

2-Attach Neoprene Foam using Contact cement

A/R Contact cement Batch: 112983 IT 10-05-12

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/05/12

(40)

Quality Control

# Work Order ID 58574

May 12, 2010 7:55:19 AM



Item ID: D350-600-241

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Start Date: 5/12/10 Start Qty: 1.00



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Required Date: 5/14/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00

Memo

0.00

Hand Finishing

2T 10-05-12

180



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

① BK 10-5-18.

190



QC

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

8 10/05/12

④

# Work Order ID 58574

May 12, 2010 7:55:24 AM



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Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-600-141

Location: \_\_\_\_\_  
PPP rev: \_\_\_\_\_

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Per 5/12/10*

*10/05/20*

*W 12-05-20*

# Picklist Print

May 12, 2010 7:54:56 AM

Page 1

10

Work Order ID: 58574

Parent Item: D350-600-241

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Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A 07.03.07 new issue ec  
IPP rev B 07.04.16 reformat.D3188 revE ec IPP Rev:C  
remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D  
10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

D3188-5 Manufactured No 110 Each 0.0000 1



Spacepod Body

D3186-3 Manufactured No 110 Each 1.0000 1



Spacepod Door, LH

Location Loc Qty Loc Code

CA 1  
52522 1

D3187-1 Manufactured No 110 Each 3.0000 1



Spacepod Floor

Location Loc Qty Loc Code

ST241B 3  
31835 3

ALS4-1032-130 Purchased No



Insert

110 Each 579.0000 28

Location Loc Qty Loc Code

ST282 579  
110511 38  
114407 541

A3235-020-935 Purchased No 110 Each 572.0000 8



Washer - Countersunk

Location Loc Qty Loc Code

ST281 572  
106150 572

RT 10-05-12

RT 10-05-12

RT 10-05-12

X1

RT 10-05-12

RT 10-05-12

X8

3114654 x 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May 12, 2010 7:54:57 AM

Work Order ID: 58574

Parent Item: D350-600-241

Parent Item Name: Spacepod, LH, AS350


Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A 07.03.07 new issue ec  
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 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

  
 D2986-1  
 Rubber Spacer

Manufactured No 130 Each 5.0000 1.05

Location Loc Qty Loc Code  
 ST242 5

57659

5

21

D3015-3  
  
 Locknut

Manufactured No 140 Each 420.0000 1

Location Loc Qty Loc Code  
 ST033 420

43758

26

56701

94

58202

300

X1

D3554-7  
  
 Ball Stud

Manufactured No 140 Each 39.0000 1

Location Loc Qty Loc Code  
 ST070 39

37674

39

21

D3567-1  
  
 Decal

Manufactured No 140 Each 15.0000 1

Location Loc Qty Loc Code  
 ST070 15

48254

15

21

RT 10-05-17

RT 10-05-12

RT 10-05-12

RT 10-05-12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Spacepod, LH. AS350

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 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

NAS1149005635

AN960JD516



Washer

D2237



Striker Plate

Purchased No 140 Each 0.0000 1

B113700 x1



RT 10-05-12

Manufactured No 140 Each 108.0000 2



RT 10-05-12

Location Loc Qty Loc Code

ST009 99

57255 40

58181 59

ST010 9

55312 9

x2

MS20426AD4-5

Purchased No

140 Each 6,064.000 4



Rivet



RT 10-05-12

Location Loc Qty Loc Code

ST317 6064

6733 1082

6874 4982

x4

D3538-1

Manufactured No

140 Each 26.0000 2



Hinge Bracket



RT 10-05-12

Location Loc Qty Loc Code

ST069 26

55012 12

56092 2

56531 12

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D  
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

D2179 Manufactured No 140 Each 57.0000 2  
 150 M  
 Doubler

RT 10-05-12

Location	Loc Qty	Loc Code
ST007	57	
35432	57	
AN526C832R24	Each	72.0000
Purchased	No	4
screw		

x2

RT 10 05 12

Location	Loc Qty	Loc Code
ST327	72	
110179	72	
AN960JD8	140	0.0000
Washer	Each	4
MS21042L08	140	451.0000
Nut	Each	4
N/A		
10.05.13		
ST300	400	
114330	400	
ST301	51	
114227	51	

RT 10 05 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<del>NASTIN 9 DN8323 Qty change from 4 to</del>					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

May 12, 2010 7:54:58 AM

Work Order ID: 58574

Parent Item: D350-600-241

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Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A 07.03.07 new issue ec  
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 remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D  
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11 Purchased No 150 Each 95.0000 2



Screw

RT 10-05-12

Location Loc Qty Loc Code

ST288 50

114382 50

ST290 45

113749 45

AN960JD8 ~~NAS1149 DN8325~~ Purchased No



Washer

NAS1515H3 Purchased No



Washer

150 Each 0.0000

M 114348 ~~20~~ x20



20M

RT 10-05-12 (PTO) =>

150 Each 146.0000 2



RT 10-05-12

Location Loc Qty Loc Code

ST277 146

111268 146

MS21042L08 Purchased No



Nut

150 Each 451.0000



x2 ~~20~~ 18M

RT 10-05-12

Location Loc Qty Loc Code

ST300 400

114330 400

ST301 51

114227 51

x4 18

(PTO) =>

W/O: 58574		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
6.5.12	150	NAS1149 DN 8325 <sup>washer</sup> change Qty from 4 to 20					S 10/05/12
		MS21042 L08 nut change Qty From 4 to 18	<del>10.05.13</del>				S 10/05/13

Part No: D350-600-241 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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May 12, 2010 7:54:58 AM

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Parent Item Name: Spacepod, LH, AS350

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remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D  
10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No 150 f 383.9834 11.34



3/4 Seal

B48173

RT 10-05-12

Location	Loc Qty	Loc Code
ST402	383.9834	

48173

D2586 Manufactured No 150 Each 139.0000 2



Door Latch

RT 10-05-12

Location	Loc Qty	Loc Code
ST006	100	

57917

Location	Loc Qty	Loc Code
ST204	39	

55314

x2

D2585 Manufactured No 150 Each 61.0000 2



Mounting Channel

RT 10-05-12

Location	Loc Qty	Loc Code
ST018	23	

55313

x2

Location	Loc Qty	Loc Code
ST019	38	

56524

D2621 Manufactured No 150 Each 103.0000 2



Latch Plate, 350 Spacepod

RT 10-05-12

Location	Loc Qty	Loc Code
ST021	103	

46842

x2

56526

May 12, 2010 7:54:59 AM

Shop Packet Print



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15 Purchased No 150 Each 92.0000 2  
Screw

ST 10-05-13

Location Loc Qty Loc Code

ST292 92

114056 92

x2

AN960JD10 NAS1149D03635 Purchased No 150 Each 0.0000 2

IT 10-05-12

Washer  
MS21042L3 Purchased No 150 Each 1,575.000 2

ST 10-05-12

Nut

Location Loc Qty Loc Code

ST300 1575

113537 20

113644 555

114523 1000

x2

D2857-1 Manufactured No 150 Each 26.0000 1

ST 10-05-12

Hinge Bracket

Location Loc Qty Loc Code

ST026 26

55019 7

56529 19

x1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 1.00

Required Qty: 1.00

D2857-2 Manufactured No 150 Each 36.0000 1



Hinge Bracket



RT 10-05-12

Location Loc Qty Loc Code

ST027 36

55020 16

56530 20

X1

D2228 Manufactured No 150 Each 54.0000 4



Bracket Plate



RT 10-05-12

Location Loc Qty Loc Code

ST009 54

30679 7

48228 47

X7

X1

AN526C832R10 Purchased No 150 Each 215.0000 10



Screw



RT 10-05-12

Location Loc Qty Loc Code

ST327 215

104603 15

113154 100

113288 50

114382 50

X2

X8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 1.00

Required Qty: 1.00

D3557-1 Manufactured No 150 Each 17.0000 1



Bracket

ST 1005-12

Location Loc Qty Loc Code

ST070 17

46887 2

50283 15

X1

AN526C832R14 Purchased No 150 Each 750.0000 2



Screw

Location Loc Qty Loc Code

ST327 750

104916 750

ST 1005-12

X2

K10021 Manufactured No 190 Each 1.0000 1



Spacepod Hardware Kit (-241)

B 58779 10-5-19

Location Loc Qty Loc Code

ST122 1

57814 1

D350-600-449 Manufactured No 190 Each 2.0000 1



Switch Relocation

CH16001

10-5-18 SP

Location Loc Qty Loc Code

FG120 2

50244 2

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Shop Packet Print

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# Picklist Print

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10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified

Start Qty: 1.00

Required Qty: 1.00

D2985

Manufactured No

190

Each

13.0000

1

10-5-18 SP



Label



## Location

## Loc Qty

## Loc Code

ST032

13

48236

3

50232

10

1

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Shop Packet Print

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**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

WLO  
58574

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F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	#	D3188	SHEET 1 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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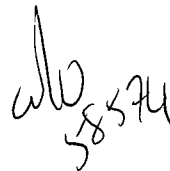
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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2009-10-20

### D3188-1 SPACEPOD BODY

MAKE FROM D3188-1M

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
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CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>JB</del>	D3188	SHEET 2 OF 1
APPROVED	<del>JB</del>	TITLE	SCALE
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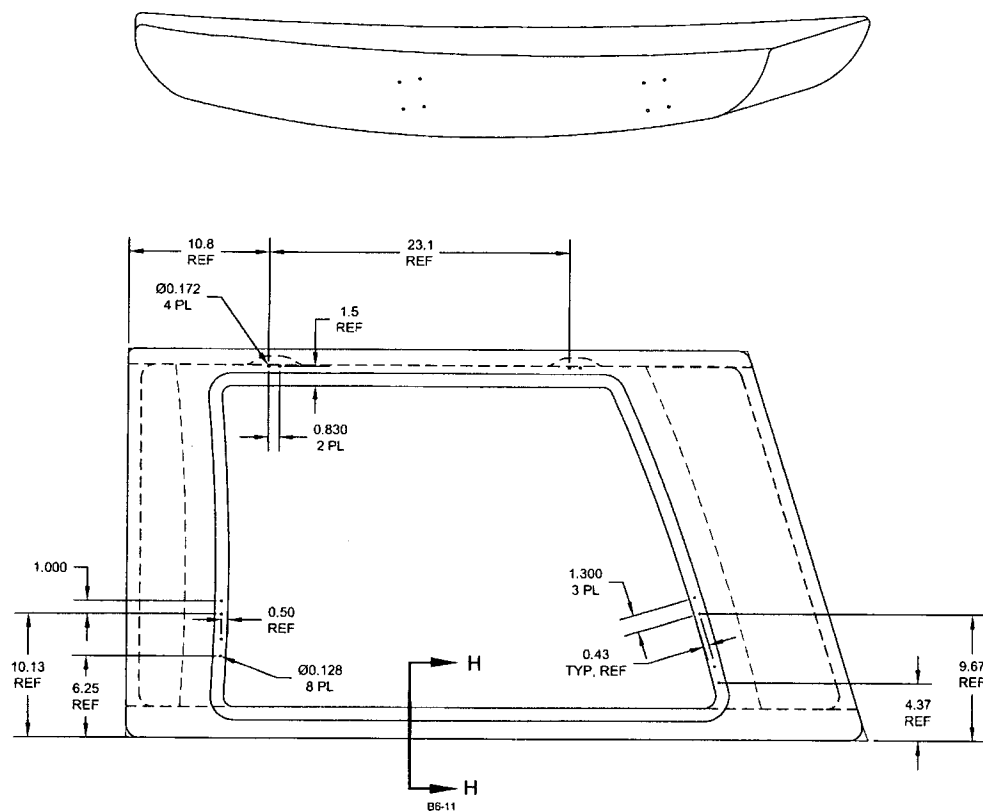
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action : Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



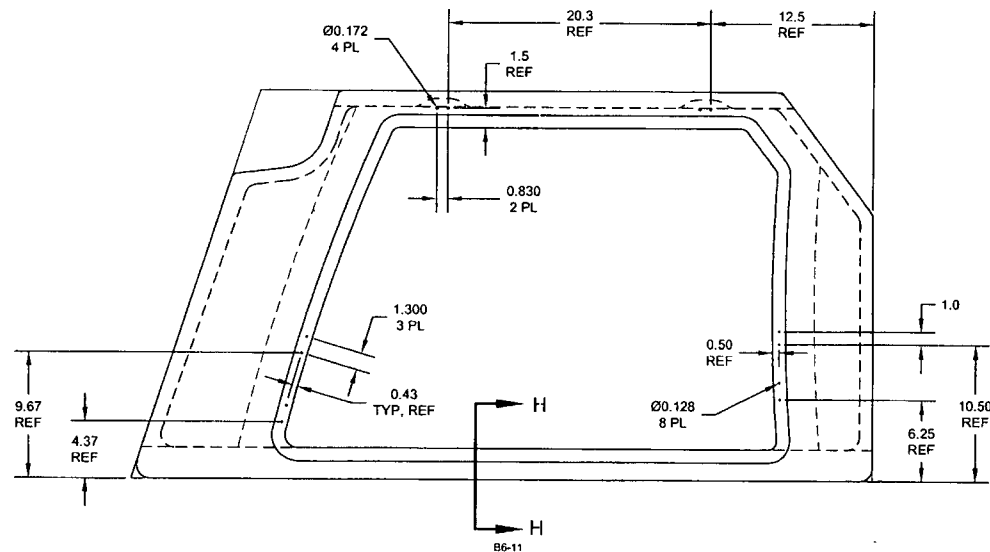
**D3188-2 SPACEPOD BODY**  
MAKE FROM D3188-2M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<del>RF</del>	D3188	SHEET 3 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
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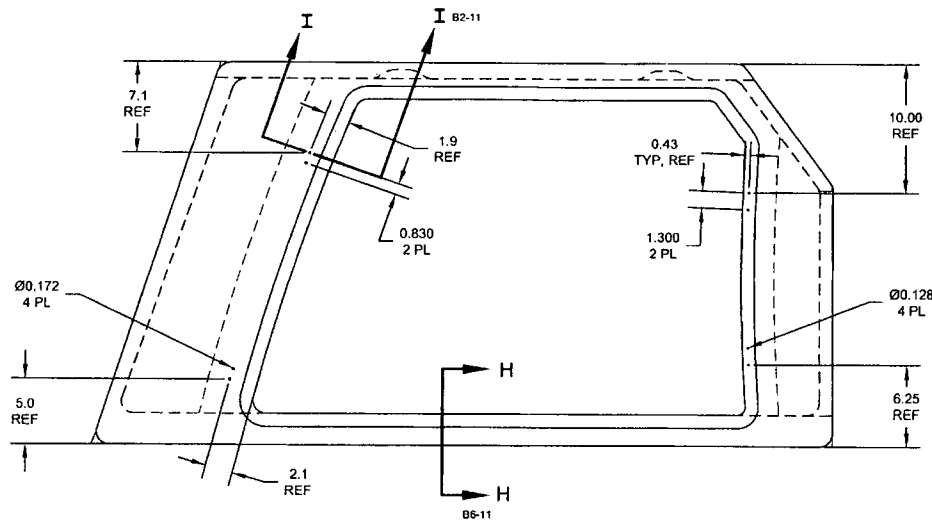
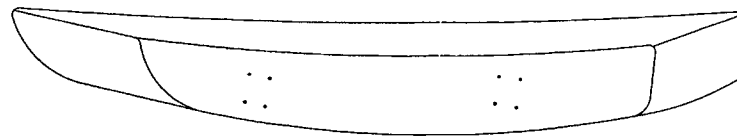
**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

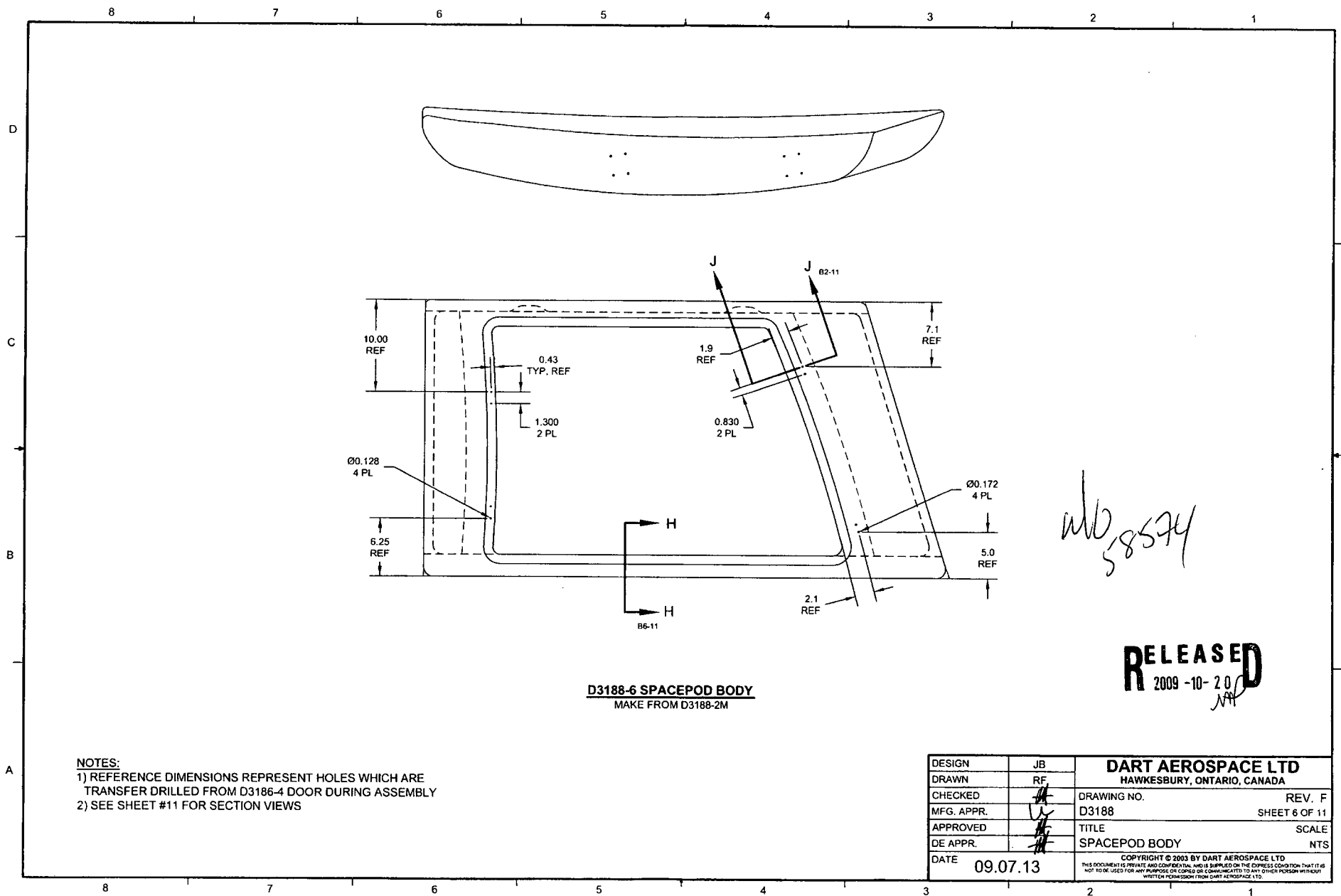
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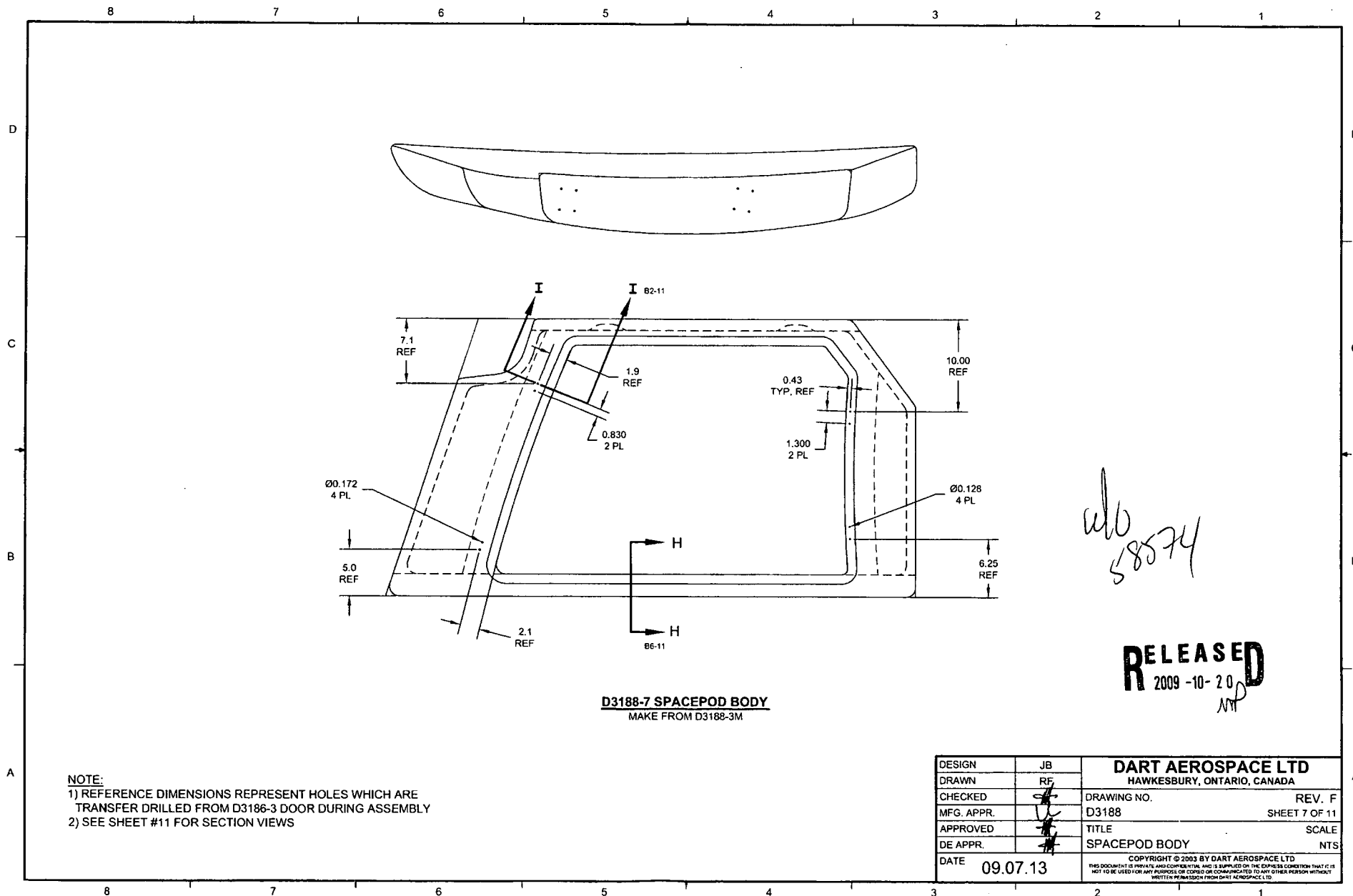
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

*W/S 58574*

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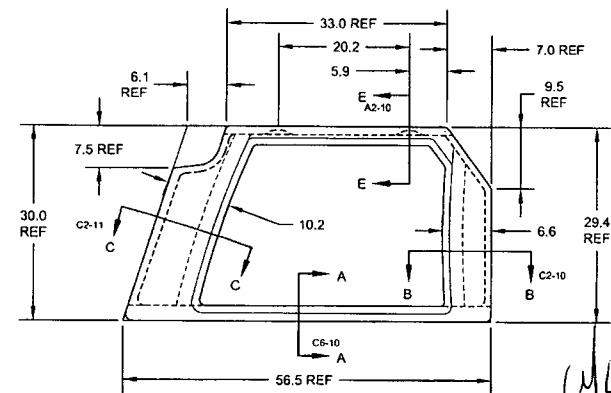
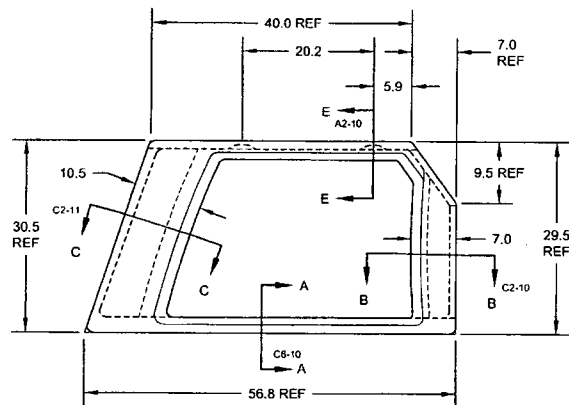
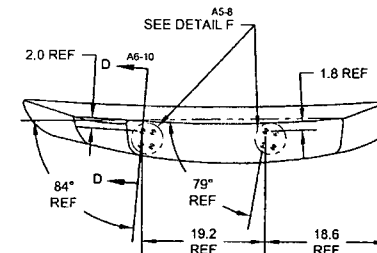
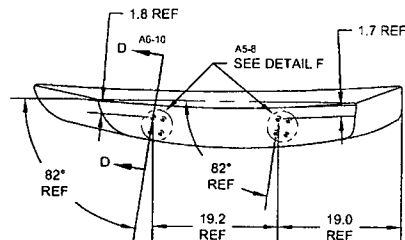
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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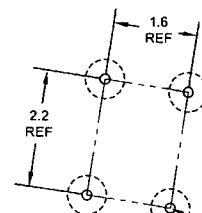
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
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**D3188-1M SPACEPOD BODY**

**D3188-3M SPACEPOD BODY**



**DETAIL F**

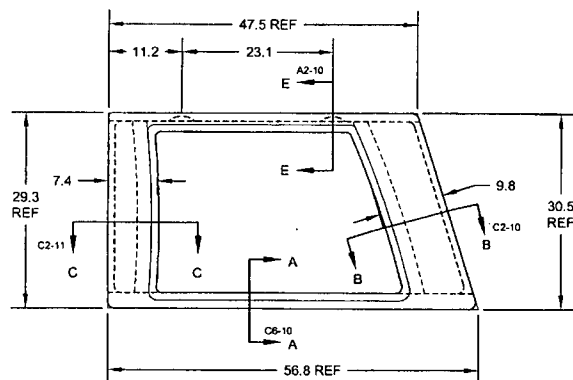
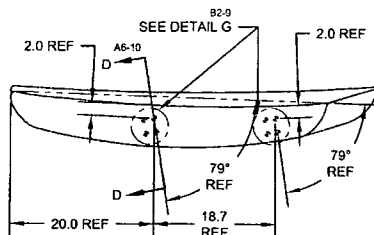
INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A5-10

**D3186-1M/-3M NOTES:**

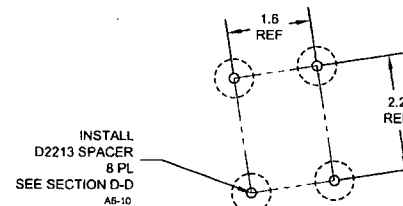
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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2009-10-20  
MP

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**D3188-2M SPACEPOD BODY**



**DETAIL G**

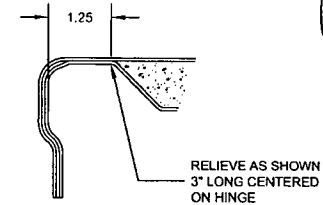
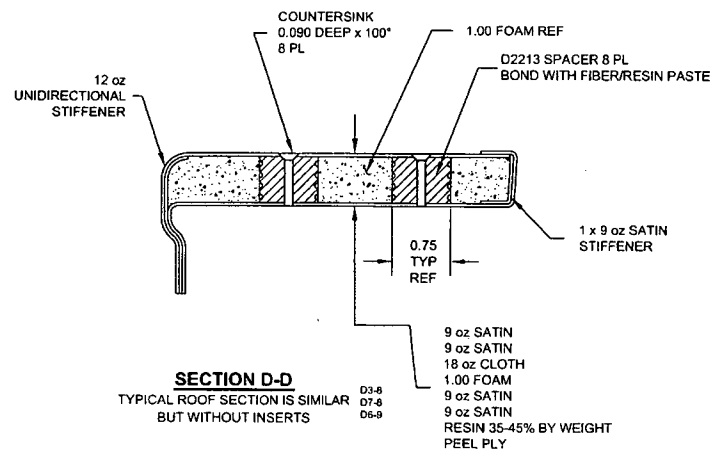
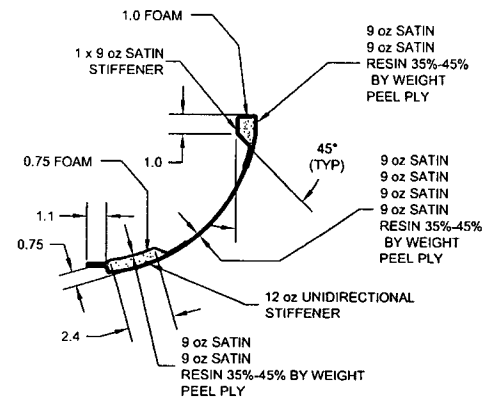
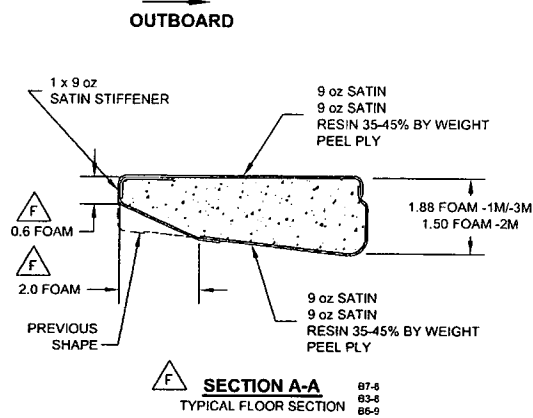
*Handwritten signature: 58574*

**RELEASED**  
2009-10-20

**D3186-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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SECTION E-E  
2 PLACES PER POD

C2-8  
C7-8  
06-8

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2009-10-27

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MFG. APPR.	<del>RF</del>	D3188	SHEET 10 OF 11
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